

Work Order ID 58021

April 21, 2010 3:58:47 PM



Page 1

Item ID: D4096-3	Accept		Setup	Start	
Revision ID: PRELIM					
Item Name: Gasket				Stop	
Start Date: 21/04/2010	Start Qty: 1.00				
Required Date: 28/04/2010	Req'd Qty: 1.00				
Reference:					

Approvals:	Process Plan: <u>RP</u>	Date: <u>10-4-21</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4096	PA1 PA2	10.04.22							

100		0.00							
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	FLOW WATER JET	0.00							
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Waterjet	Memo	0.00							
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FLOW CNC Waterjet	1-Cut as per Dwg D4096								
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	Dwg Rev: <u>PA1</u>								
--	---------------------	--	--	--	--	--	--	--	--

	Prog Rev:								
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	2-Deburr if necessary								
--	-----------------------	--	--	--	--	--	--	--	--

110		0.00							
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	QC2- Inspect parts off machine FAI/FAIB	0.00							
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QC	Memo	0.00							
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Quality Control									
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120		0.00							
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	QC8- Inspect parts - second check	0.00							
--	-----------------------------------	------	--	--	--	--	--	--	--

QC	Memo	0.00							
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Quality Control									
-----------------	--	--	--	--	--	--	--	--	--

→ inspect to DAD Dwg 10/04/23 & 4 only

FB 10-4-22



HB 10-4-22

QC APPROVAL

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4096-3 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: / Date: 10/5/19
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 58021		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/1/26	#120	Scrap dm + 4 parts. R.C. Design change.	 10/04/26	Scrap + Destroy dm + 4 no replace	SAD 10-04-27	S 10/1/27	 10/04/26 for 58021	S 10/04/27

NOTE: Date & initial all entries

Work Order ID 58021

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Item ID: D4096-3

Accept



Setup Start



Revision ID: PRELIM

Item Name: Gasket

Stop



Start Date: 21/04/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Scrap

POSITIVE RECALL

EFFECTIVE _____ AUTH _____
RELEASED _____ DATE _____

U 100520

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 58021



Parent Item: D4096-3



Parent Item Name: Gasket

Start Date: 21/04/2010

Required Date: 28/04/2010

Comments: IPP Rev:A new issue DD 10.04.21 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MNEO60S.063 NEOPRENE SHEET 0.063		Purchased	No			100	sf	272.5000	2.2735			

B310-4-02

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT052

272.5

114176

272.5

114176

SCRAP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 58021
Description: GASKET		Part Number: D4096-3
Inspection Dwg: D4096-3 Rev: P02 P02		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

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First Article

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Prototype

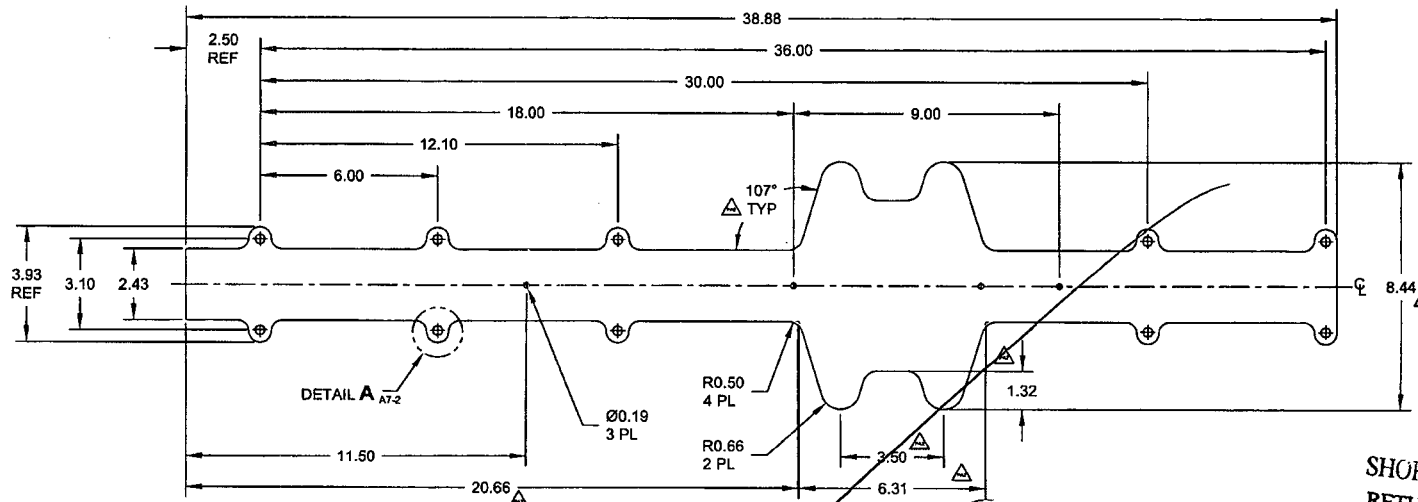
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .19	+.005-.001	.19	✓			
.300	±.010	.308	✓			
.300	±.010	.306	✓			
2.43	±.030	2.424	✓			
3.10	±.030	3.096	✓			
3.93	±.030	3.920	✓			
2.50	±.030	2.504	✓			
6.00	±.030	6.008	✓			
12.10	±.030	12.10	✓			
18.00	±.030	18.00	✓			
9.00	±.030	9.00	✓			
30.00	±.030	30.00	✓			
36.00	±.030	36.00	✓			
38.88	±.030	38.875	✓			
8.44	±.030	8.435	✓			
1.32	±.030	1.34	✓			
3.00	±.030	3.00	✓			
6.31	±.030	6.31	✓			
11.50	±.030	11.50	✓			
20.66	±.030	20.66	✓			
.063	±.010	.063	✓			

Measured by: PB
Date: 10-4-20

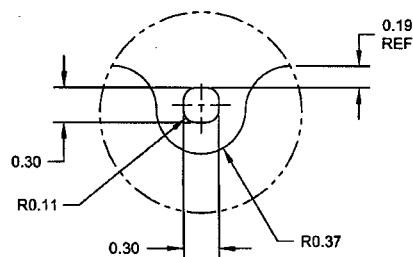
Audited by: S
Date: 10/04/20

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4096-3 GASKET 1



DETAIL A: TAB DETAIL
SCALE 4X C3-1 C6-2

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 56021

10.04.22

PRELIMINARY ISSUE
10.04.22

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA2
MFG. APPR.		D4096	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		GASKET	NTS
DATE	10.04.22	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	